

Date: Monday, 02/02/2009 3:48:18 PM  
 User: Julie Dawson

## Process Sheet

|                                  |  |                         |                            |
|----------------------------------|--|-------------------------|----------------------------|
| <b>Customer</b>                  | : CU-DAR001 Dart Helicopters Services  | <b>Drawing Name</b>     | : BASKET BASE ASS'Y (A119) |
| <b>Job Number</b>                | : 45427B   |                         |                            |
| <b>Estimate Number</b>           | : 12431  |                         |                            |
| <b>P.O. Number</b>               | :  | <b>Part Number</b>      | : D3516041                 |
| <b>This Issue</b>                | : 02/02/2009   | <b>S.O. No.</b>         | :                          |
| <b>Prsht Rev.</b>                | : NC   | <b>Drawing Number</b>   | : D3516 REV C              |
| <b>First Issue</b>               | : / /  | <b>Project Number</b>   | : N/A                      |
| <b>Previous Run</b>              | : 45426B   | <b>Drawing Revision</b> | : C                        |
|                                  | <b>Type</b> : LARGE FAB ASSY   | <b>Material</b>         | :                          |
| <b>Written By</b>                | :  | <b>Due Date</b>         | : 15/03/2009               |
| <b>Checked &amp; Approved By</b> | : <u>JUD 09.02.03</u>  | <b>Qty:</b>             | 1 Um: Each                 |
| <b>Comment</b>                   | : EST rev. A 06.05.31 Preliminary EC<br>: EST rev. b 06.07.27 updated EC<br>Est Rev:C 08-02-25 ECN 1138P DD verified by: LL<br>Est Rev:D 08-03-18 ecn 1136 DD verified by: |                         |                            |

## Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

|     |        |      |
|-----|--------|------|
| 1.0 | D34421 | Shim |
|-----|--------|------|



**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
 Shim  
 Batch: B45226

PD 09-03-11

|     |       |                  |
|-----|-------|------------------|
| 2.0 | D2581 | Mounting Bracket |
|-----|-------|------------------|



**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
 Mounting Bracket  
 Batch: B43800

PD 09-03-11

|     |         |        |
|-----|---------|--------|
| 3.0 | D351611 | Clevis |
|-----|---------|--------|



**Comment:** Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)  
 CLEVIS  
 batch: B37619-1 B45714-5

PD 09-03-11

|     |         |        |
|-----|---------|--------|
| 4.0 | D351613 | Clevis |
|-----|---------|--------|



**Comment:** Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)  
 CLEVIS  
 batch: B37620-2 B45564-2

PD 09-03-11

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

Date: Monday, 02/02/2009 3:48:18 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSY (A119)

Job Number: 454278

Part Number: D3516041

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

|     |        |                |
|-----|--------|----------------|
| 5.0 | D23273 | Spacer Bushing |
|-----|--------|----------------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spacer Bushing

Batch: B44365

PD 09-03-11

|     |        |              |
|-----|--------|--------------|
| 6.0 | D22323 | Basket Hinge |
|-----|--------|--------------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Basket Hinge

Batch: B46084

PD 09-03-11

|     |        |             |
|-----|--------|-------------|
| 7.0 | D31661 | Basket Hoop |
|-----|--------|-------------|



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

RIB

Batch: B46061

PD 09-03-09

|     |        |      |
|-----|--------|------|
| 8.0 | D37251 | Hoop |
|-----|--------|------|



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

HOOP

batch: B45575

PD 09-03-09

|       |                |                           |
|-------|----------------|---------------------------|
| ✓ 9.0 | M304TS0750W065 | 304 SQ Tube .75x.75x.065W |
|-------|----------------|---------------------------|



Comment: Qty.: 53.1825 f(s)/Unit Total : 53.1825 f(s)

AISI 304 SQ Tube .75x.75x.065W

Batch: M110561

SAD 09-02-13 (D)

|      |             |                               |
|------|-------------|-------------------------------|
| 10.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|------|-------------|-------------------------------|



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut rib D3516-1 as per dwg D3516

2-Cut rib D3516-3 as per dwg D3516

3-Cut rib D3516-5 as per dwg D3516

4-Cut rib D3516-7 as per dwg D3516

5- Cut rib D3516-15 as per dwg D3516

SAD 09-02-13 (D)

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

Date: Monday, 02/02/2009 3:48:18 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASS'Y (A119)

Job Number: 45427B

Part Number: D3516041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6-Cut rib D3516-9 from D3166-1 (4) using DT8365 jig

PD 09-03-11

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3516

PD 09-03-11

12.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PL 09-03-10

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PD 09-03-11

14.0

M304EX07516F

Expanded Metal Flat SS



Comment: Qty.: 60.0000 sf(s)/Unit Total : 60.0000 sf(s)

Expanded Metal Flat Stainless steel

Batch: M110992

PD 09-03-12

15.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut expanded metal for base as per dwg D3516

2-Cut expanded metal for base ends as per dwg D3516

3-Weld expanded metal to base as per dwg D3516

PD 09-03-13

16.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PL 09-03-13

17.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PD 09-03-13

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

Date: Monday, 02/02/2009 3:48:18 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASS'Y (A119)

Job Number: 45427B

Part Number: D3516041

Job Number:



Seq. #: Machine Or Operation: Description :

18.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

M 110939  
Pressure wash MD/ JH 09/03/16

1ST COAT:

START TIME: 10:30AM

OVEN TEMPERATURE: 400°C

FINISH TIME: 11:00AM

\*\*\*\*\* 2nd coat if necessary \*\*\*\*\*

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

gsl 09-03-16 (X)

19.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

S 09/03/16 (X)

20.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

PM 45427 P 09/3/16 (X)

21.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/19 (X)

Job Completion



MF 09-03-18

# Dart Aerospace Ltd

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

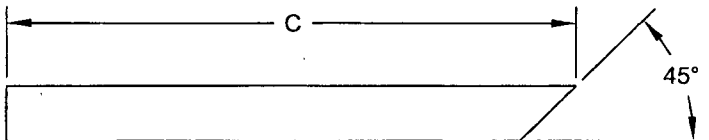
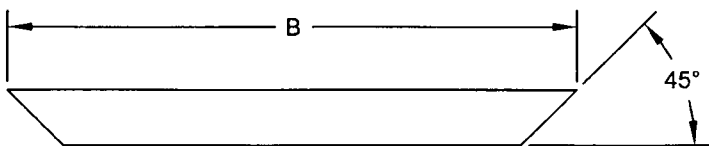
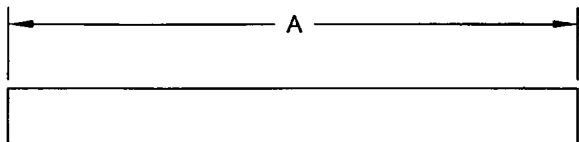
| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



**PARTS LIST FOR D3516-041 BASKET BASE ASSEMBLY**

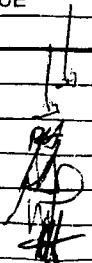
| PART NO  | QUANTITY | LENGTH<br>A | LENGTH<br>B | LENGTH<br>C | DESCRIPTION             |
|----------|----------|-------------|-------------|-------------|-------------------------|
| D2232-3  | 2        | N/A         | N/A         | N/A         | HINGE PLATE             |
| D2327-3  | 2        | N/A         | N/A         | N/A         | BUSHING                 |
| D2581    | 2        | N/A         | N/A         | N/A         | MOUNTING BRACKET        |
| D3442-1  | 2        | N/A         | N/A         | N/A         | SHIM                    |
| D3516-1  | 2        | —           | 102.00      | —           | RIB                     |
| D3516-3  | 2        | —           | —           | 2.70        | RIB                     |
| D3516-5  | 8        | 26.75       | —           | —           | RIB                     |
| D3516-7  | 3        | 45.50       | —           | —           | RIB                     |
| D3516-9  | 4        | N/A         | N/A         | N/A         | RIB (MAKE FROM D2235-3) |
| D3516-11 | 6        | N/A         | N/A         | N/A         | CLEVIS                  |
| D3516-13 | 4        | N/A         | N/A         | N/A         | CLEVIS                  |
| D3516-15 | 2        | —           | —           | 19.32       | RIB                     |
| D3725-1  | 2        | N/A         | N/A         | N/A         | HOOP                    |



**D3516-041 BASKET BASE ASSEMBLY NOTES:**

- MATERIAL:  
FRAME - AISI 304/316 STAINLESS STEEL SQUARE TUBING, 3/4 X 3/4 0.065 WALL  
(REF. DART SPEC. M304TS0.750W.065)  
MESH - 3/4-16F EXPANDED STAINLESS STEEL  
(REF. DART SPEC. M304EX0.75-16F)
- FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE GLOSS (4.3.5.2) PER DART QSI 005 4.3
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- IDENTIFICATION: N/A
- WEIGHT: 75 lbs
- WELDING: PER DART QSI 004

RELEASED  
08.03.17  
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WITHOUT NOTICE  
WORK ORDER  
NO. 15521B

|            |   |  |              |
|------------|---|--|--------------|
| C          | ADD D3725-1 (ZNA7-3) AND D3516-15 (ZNA5-3), QTY.(1) PER END OF BASKET BASE; SHORTEN D3516-3 (REF. ECN#1136); REASON: CUSTOMER REQUEST | MB   | 08.02.20     |
| B          | ADD QTY.(4) D3516-13; QTY.(6) D3516-11 WAS QTY.(1) SEE TR-D119-756-1 REV. A   | MB   | 06.07.25     |
| A          | NEW ISSUE   | MB   | 06.06.21     |
| REV.       | DESCRIPTION   | BY   | DATE         |
| DESIGN     |    | <b>DART AEROSPACE LTD</b><br><b>HAWKESBURY, ONTARIO, CANADA</b>  |              |
| DRAWN      |   |  |              |
| CHECKED    |   | DRAWING NO.  | REV. C       |
| MFG. APPR. |   | D3516  | SHEET 1 OF 4 |
| APPROVED   |   | TITLE  | SCALE        |
| DE APPR.   | BASKET BASE ASSEMBLY  | NTS  |              |
| DATE       | 08.02.20  | COPYRIGHT © 2006 BY DART AEROSPACE LTD<br>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. |              |

8

7

6

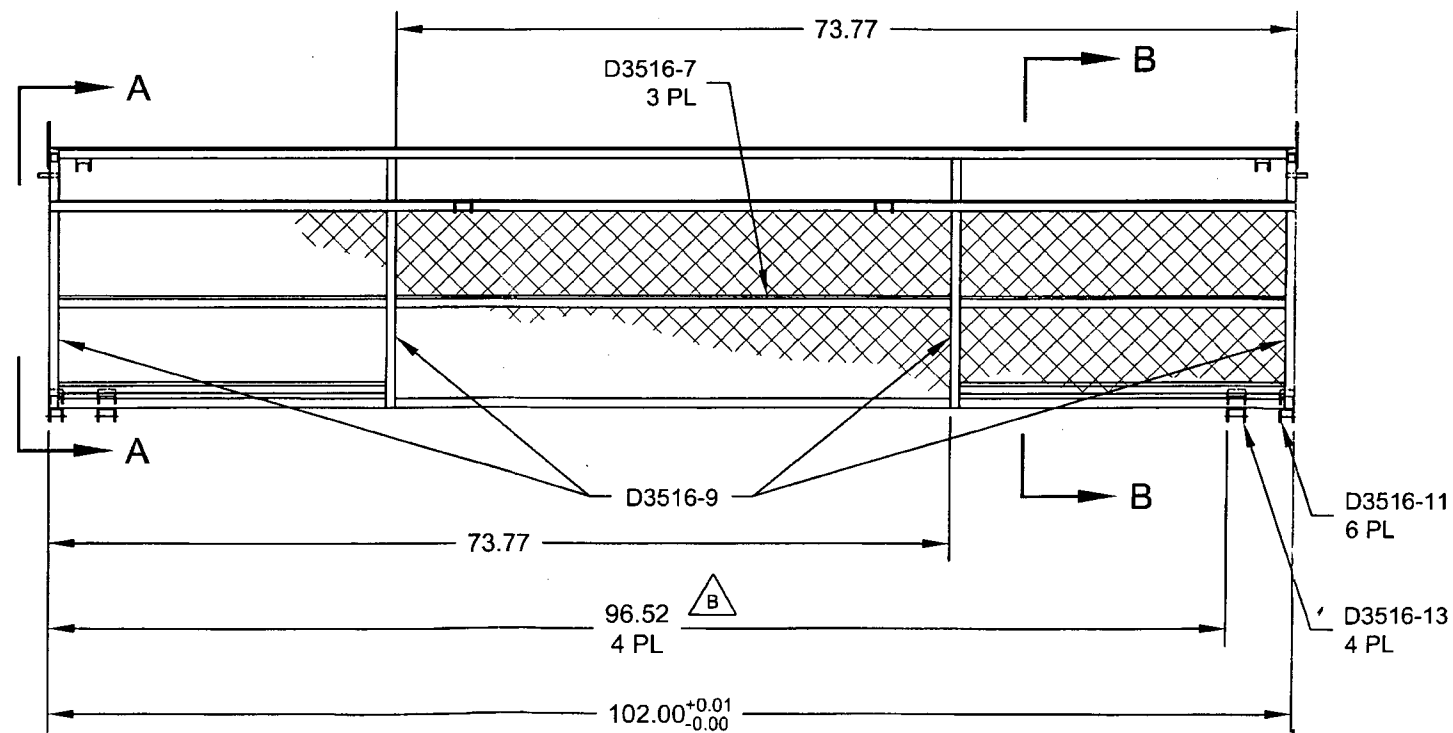
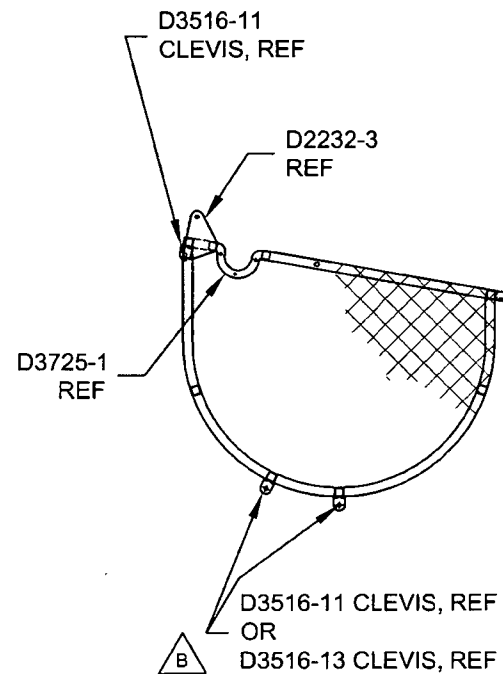
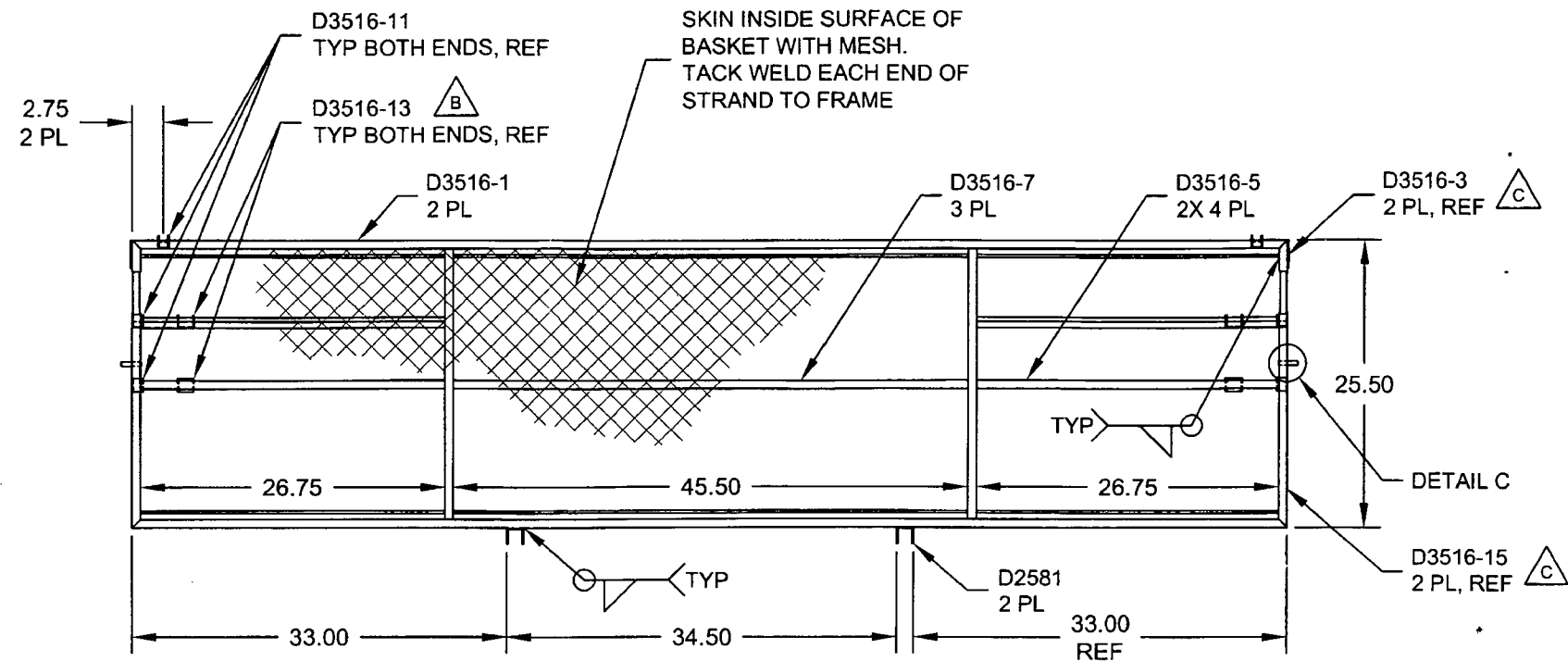
5

4

3

2

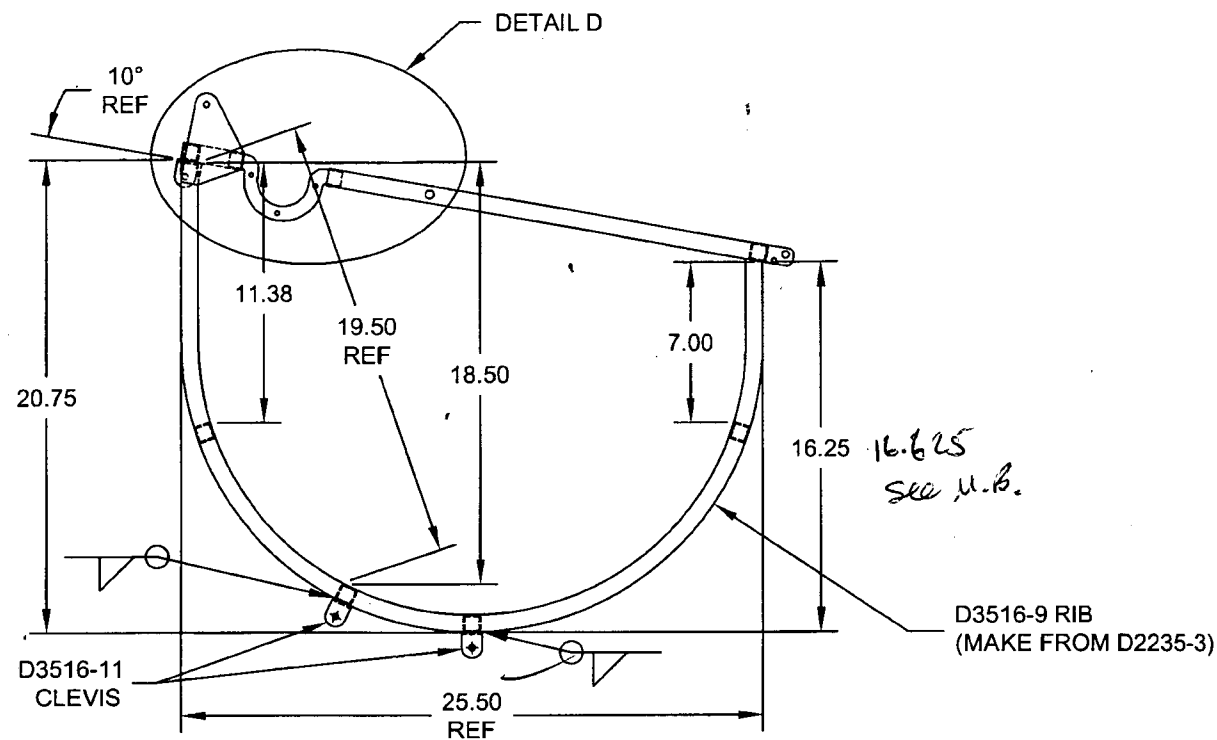
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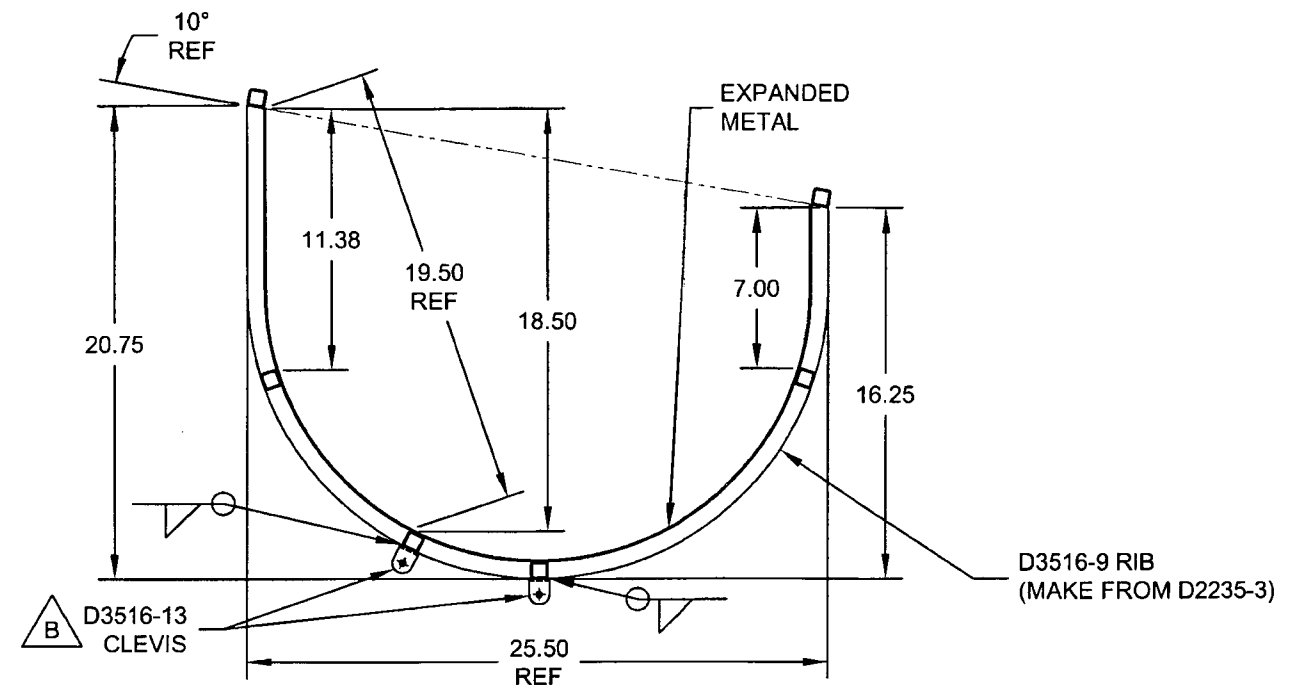
### D3516-041 BASKET BASE ASSEMBLY

|   |          |  |              |
|---|----------|--|--------------|
| DESIGN  |          | <b>DART AEROSPACE LTD</b>              |              |
| DRAWN   |          | <b>HAWKESBURY, ONTARIO, CANADA</b>     |              |
| CHECKED   |          | DRAWING NO.                            | REV. C       |
| MFG. APPR.  |          | D3516                                  | SHEET 2 OF 4 |
| APPROVED  |          | TITLE                                  | SCALE        |
| DE APPR.  |          | BASKET BASE ASSEMBLY (A119)            | NTS          |
| DATE  | 08.02.20 | COPYRIGHT © 2006 BY DART AEROSPACE LTD |              |
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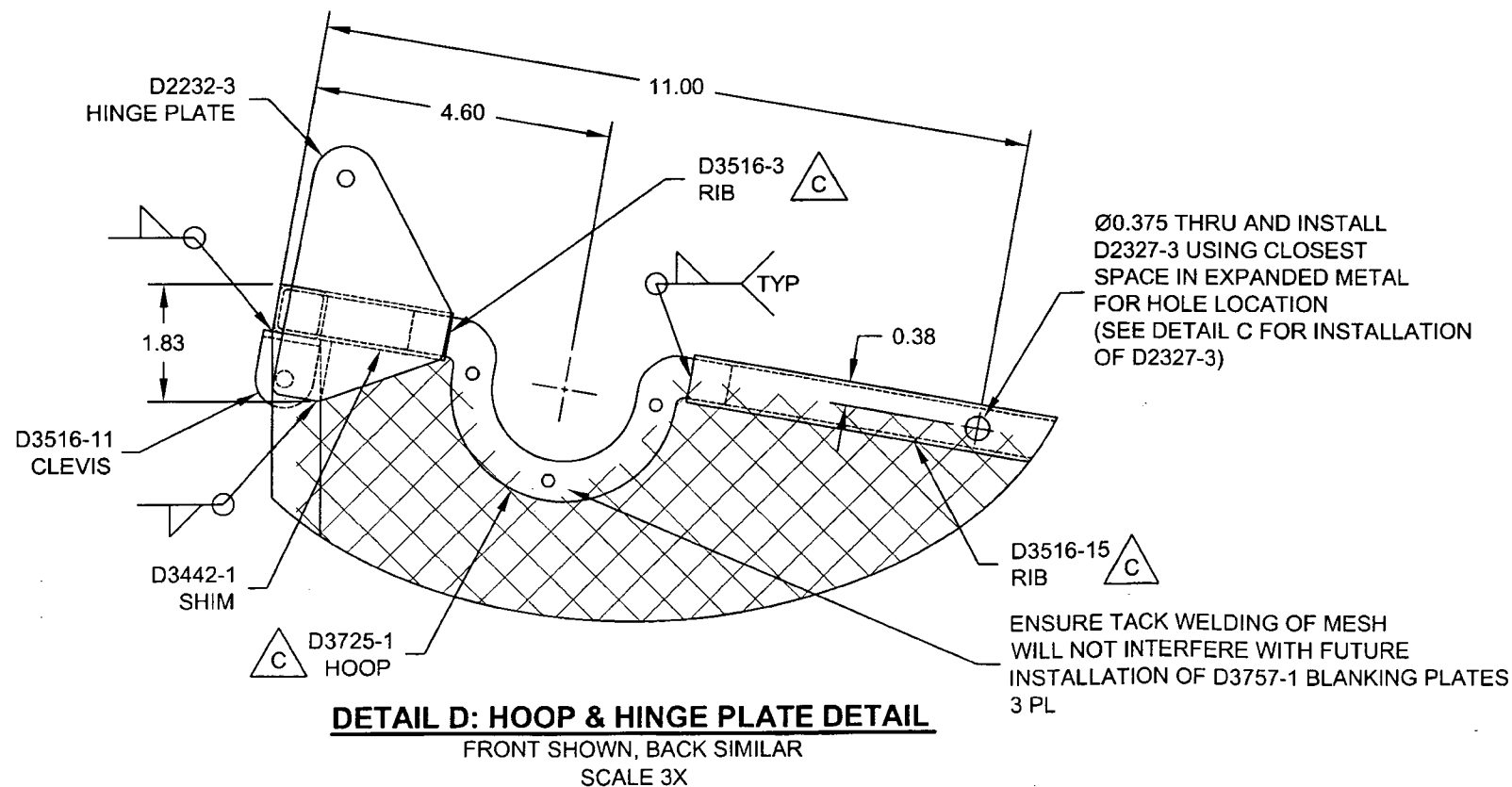
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WORK ORDER  
NO. 45421B



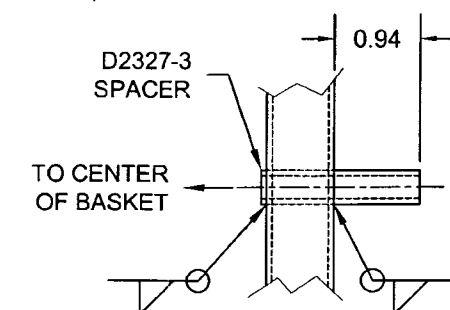
**SECTION A-A: END RIB DETAIL**  
(MESH NOT SHOWN FOR CLARITY)  
TYP BOTH ENDS



**SECTION B-B: CENTER RIB DETAIL**  
2 PL



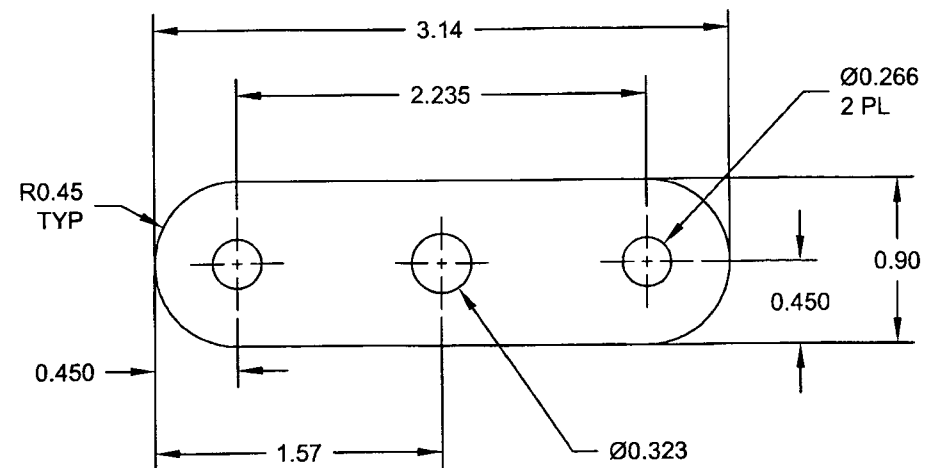
**DETAIL D: HOOP & HINGE PLATE DETAIL**  
FRONT SHOWN, BACK SIMILAR  
SCALE 3X



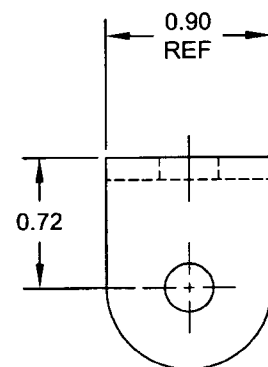
**DETAIL C: SPACER INSTALLATION**  
SCALE 4X

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WORK ORDER  
NO. 454218

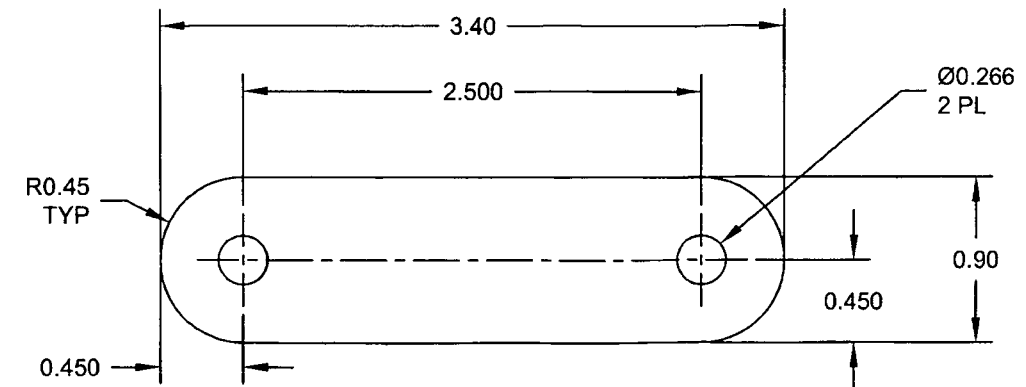
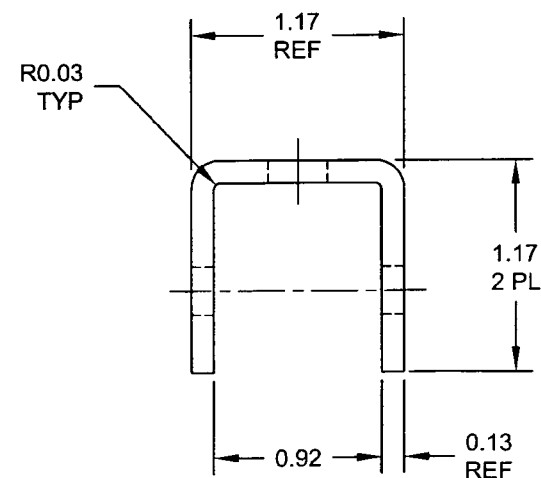
|  |          |  |              |
|--|----------|--|--------------|
| DESIGN   |          | <b>DART AEROSPACE LTD</b>              |              |
| DRAWN  |          | <b>HAWKESBURY, ONTARIO, CANADA</b>     |              |
| CHECKED  |          | DRAWING NO.                            | REV. C       |
| MFG. APPR.   |          | D3516                                  | SHEET 3 OF 4 |
| APPROVED   |          | TITLE                                  | SCALE        |
| DE APPR.   |          | BASKET BASE ASSEMBLY                   | NTS          |
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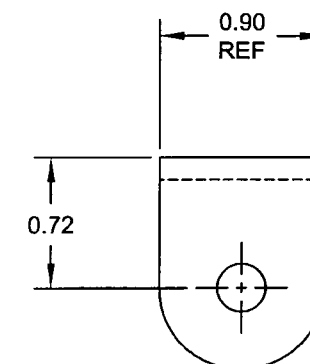
1 D3516-11F CLEVIS FLAT PATTERN



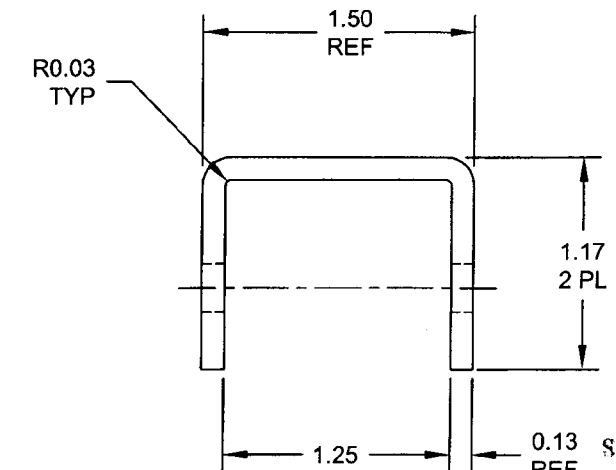
D3516-11 CLEVIS BENDING DETAIL  
(MAKE FROM D3516-11F)



1 D3516-13F CLEVIS FLAT PATTERN



D3516-13 CLEVIS BENDING DETAIL  
(MAKE FROM D3516-13F)



**D3516-11/-13 NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR AMS 5524, 11 GAUGE (0.125 THICK)  
(REF. DART SPEC. M304S11GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3516-11 = 0.09 lbs  
D3516-13 = 0.10 lbs

|            |          |  |              |
|------------|----------|--|--------------|
| DESIGN     |          | <b>DART AEROSPACE LTD</b>  |              |
| DRAWN      |          | HAWKESBURY, ONTARIO, CANADA  |              |
| CHECKED    |          | DRAWING NO.  | REV. C       |
| MFG. APPR. |          | D3516  | SHEET 4 OF 4 |
| APPROVED   |          | TITLE  | SCALE        |
| DE APPR.   |          | BASKET BASE ASSEMBLY (A119)  | NTS          |
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